

Date: Monday, 22/12/2008 3:06:15 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	PEDAL LOCK COVER
Job Number :	44256		
Estimate Number :	10445		
P.O. Number :		Part Number :	D33683
This Issue :	22/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3368 REV B
First Issue :	/ /	Project Number :	N/A
Previous Run :	40206	Drawing Revision :	B
Written By :		Material :	
Checked & Approved By :	<u>JLD 08.12.23</u>	Due Date :	20/01/2009
Comment :	Est. A 05.01.27 New issue KJ/JLM Est Rev:B 08-07-15 add QC3 DD verified by:ec		

Qty: 6 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

- 1.0	M6061T6B2000X02000	6061-T6 Bar 2.00 x 2.00
-------	--------------------	-------------------------



Comment: Qty.: 0.9277 f(s)/Unit Total : 5.5661 f(s)
 Material: 6061-T6 Bar (QQ-A-225/8 or QQ-A-200/8)
 (M6061T6B2.000x02.000)
 Batch: M110167

mr 09/01/02

6

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: Machine D3368-3 as per Folio FA500 and Dwg D3368
 Identify as D3368-3
 Deburr

J.F. / mr 09/01/06

6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / mr 09/01/03

6

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

JL 09/01/07

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

FX 09/01/08

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 3:06:15 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK COVER

Job Number: 44256

Part Number: D33683

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M18052



(6x)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:00
320 OF
3:30

M-1 09/01/09

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M 09-01-09 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



6x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 491

9/1/12

SLP

9.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44254
Description: Pedal Lock Cover		Part Number: D3368-3
Inspection Dwg: D3368	Rev: B	Page 1 of 1

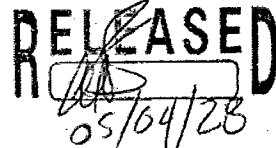
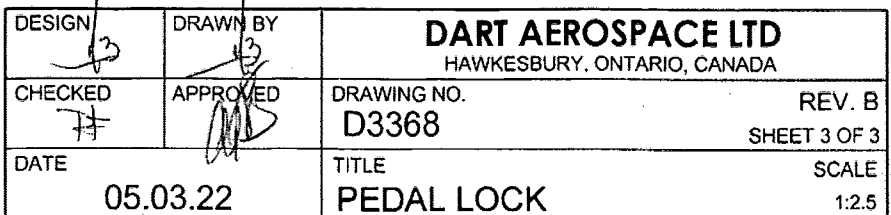
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.25	+/-0.030	10.251	✓			
7.250	+/-0.010	7.250	✓			
0.650	+/-0.010	.657	✓			
0.107	+/-0.010	.108	✓			
1.800	+/-0.010	1.798	✓			
45°	+/-0.5°	45°	✓			
Ø1.300	+/-0.010	Ø1.299	✓			
Ø1.400	+/-0.010	Ø1.395	✓			
Ø1.031	+/-0.010	Ø1.027	✓			
0.250	+/-0.010	.250	✓			
1.500	+/-0.010	1.501	✓			
1.440	+/-0.010	1.441	✓			
2.00	+/-0.030	2.000	✓			
7°	+/-0.5°	7°	✓			
0.635	+0.010/-0.000	.638	✓			
Ø1.250	+/-0.005	Ø1.249	✓			
0.250 deep	+/-0.010	.249	✓			
1.000	+/-0.010	.998	✓			
1.450	+/-0.010	1.450	✓			
0.375	+/-0.010	.375	✓			
0.310	+/-0.010	.310	✓			
Ø0.750	+0.010/-0.000	.750	✓			
Ø0.185	+0.005/-0.000	Ø.188	✓			

Measured by: J.F.	Audited by: J.L.	Prototype Approval:	N/A
Date: 09/01/06	Date: 09/01/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue	KJ/JLM	
B	05.05.25	Dimensions and tolerances changed	KJ/JLM	
C	08.07.23	Ø0.201 & Ø0.136 dimensions removed	KJ/DD	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

